

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
1 November 2001 (01.11.2001)

PCT

(10) International Publication Number
WO 01/81082 A1

(51) International Patent Classification⁷: B32B 35/00 (74) Agent: BARICEVAC, Donald, A.; Ostrager Chong & Flaherty LLP, 30th Floor, 825 Third Avenue, New York, NY 10022 (US).

(21) International Application Number: PCT/US01/12960 (81) Designated States (national): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW.

(22) International Filing Date: 23 April 2001 (23.04.2001) (84) Designated States (regional): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

(25) Filing Language: English (30) Priority Data: 09/556,277 24 April 2000 (24.04.2000) US (71) Applicant: SEAMTEK INTERNATIONAL [US/US]; 4100 McGhee Road, Sandpoint, ID 83864 (US).

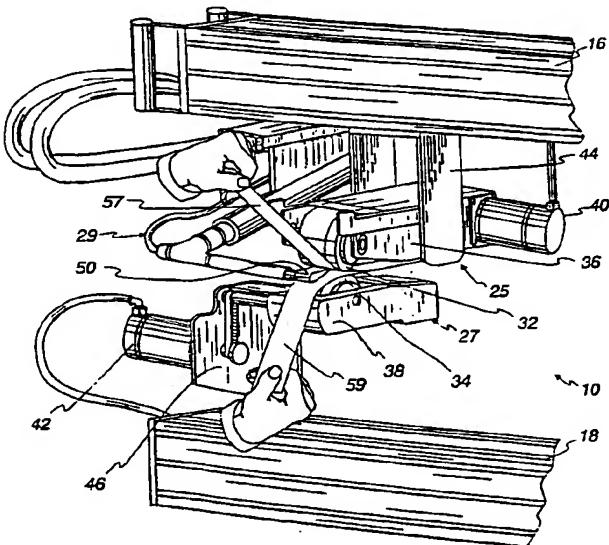
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Published:

— with international search report

[Continued on next page]

(54) Title: ROTARY HOT AIR WELDER AND STITCHLESS SEAMING



WO 01/81082 A1

(57) Abstract: The present invention provides a hot air welding apparatus (10) that provides accurate and repeatable control of the drive wheel (32,24) speed. To afford very precise control of the speed and the relative rotation of the drive wheels at all times during the welding process, the present invention is provided with a computer control system (23) and two high torque stepper motors (40,42), one for each drive wheel. The computer control system allows the speed and position of the drive wheels to be regulated with a very high accuracy. The computer control system allows the drive wheel settings to be adjusted while the seam is being welded and further includes an automatic ramp capability, a repeat mode, and a test strip mode. Further, the computer control system is capable of controlling the temperature of the air used in the welding process.



For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

ROTARY HOT AIR WELDER AND STITCHLESS SEAMING**BACKGROUND OF THE INVENTION**

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This invention relates generally to apparatuses and methods for joining materials and the products created by the joining methods. More particularly, the invention relates to apparatuses and methods for welding pieces of 10 industrial textiles, such as thermoplastic materials or thermoplastic coated fabrics, together. The invention further relates to joining, by welding or with adhesive tape, fabrics intended for use in the garment industry, particularly the outdoor technical clothing industry, 15 without employing traditional sewing techniques to join fabric pieces.

The industrial textile industry is based on the availability of a variety of thermoplastic extruded sheeting 20 and thermoplastic coated fabrics. These materials are used to make a wide range of products such as, for example, inflatable boats, hot air balloons, covers for outdoor structures, geo-membranes for lining toxic waste sites, awnings and tents, outdoor banners, artistic fabric 25 sculptures, liquid transportation containers, dry bags, and

waterproof storage sacks. The products are generally lightweight, can be folded to a small size when not in use, have coatings that are generally impervious to industrial chemicals, and can be purchased in a wide range of colors,

5 textures and fabric weights. Such fabrics generally come in approximately 5 to 12 foot wide rolls and thus must be cut into the required pattern pieces before being joined together to make the completed product.

There are three basic methods by which pieces of coated 10 fabric can be joined together to create a mechanical bond as well as water-tight and gas tight seams: traditional sewing followed by applying waterproof tape to the seam, gluing, and heat sealing (also called welding). Fabrics coated with certain rubber based coatings, such as Hypalon (manufactured 15 by DuPont) can only be glued or sewn. Most of the newer coatings including polyurethane, polyvinylchloride, polypropylene, and polyethylene can either be glued or welded. However, gluing can be very labor intensive and further is subject to strict scrutiny from the Occupational 20 Safety and Health Administration ("OSHA") due to the volatile solvents that are employed during the gluing operation. Most gluing now takes place in countries other than the United States.

There are four main methods of heat sealing or welding 25 in use: hot wedge, radio frequency ("RF"), ultrasonic, and

hot air. In the hot wedge method, two fabric pieces are drawn across a hot iron (or wedge) and then are pressed together. This method is quite similar to the hot air process with only the heat delivery system being different.

5 One disadvantage of this method is that the wedge can become contaminated with dirt and melted plastic which then reduces the amount of heat delivered to the seam. Further, hot wedge welders typically experience a hot section immediately after the beginning of the weld as the wedge 10 accumulates excess heat when idle. Another disadvantage is that, since the heat energy must pass through a solid object to reach the seam, the maximum speed of the hot wedge welding process is limited by the thermal conductivity of the wedge.

15 The RF method is probably the most widely used approach for heat sealing. The RF welder is basically an antenna (the die) that is poorly matched to the amplifier, thereby producing a great deal of heat rather than radio waves between the antenna and the underlying plate. In practice, 20 the two fabric pieces are laid on the plate. The die is then brought down, thereby pressing the two pieces together. The operator then initiates the welding process by pressing a pair of push buttons. The actual RF process takes from about 5 to 15 seconds, depending upon the thickness of the 25 pattern pieces and the amount of RF energy available from

the machine.

There are, however, several disadvantages to the RF method. RF welding is a slow process because the size of the die is limited by the available energy of the unit.

5 Typical RF welding dies are about 1 to 3 feet in length and approximately 2 inch wide. There is also some concern about the operator's health and safety as the operator is usually inches from an intense RF source which may be activated several hundred times in a typical shift. While RF health
10 hazards have not been documented, it is known that stray RF energy from such machines can damage electrical equipment within approximately 50 feet of the machine and can light fluorescent fixtures located nearby. In addition, due to the die and plate arrangement, the RF method is typically
15 limited to seams or joints that can be laid flat for welding. Three dimensional dies and plates are occasionally used, but are quite expensive and require a vacuum or other methods to hold the fabric in position as the die is applied. Further, the Federal Communications Commission
20 ("FCC") has become increasingly strict regarding emissions of stray RF energy from industrial sources. Because of the increasingly strict FCC regulations, new RF welding equipment can typically cost \$80,000 or more.

Ultrasonic welding is a process that is like RF
25 welding, with the exception of the energy source. Rather

than using radio waves, ultrasonic welding uses sound waves that basically vibrate the fabric molecules until sufficient heat is generated to melt the coatings.

In general, hot air welding is much faster than other 5 methods, can accommodate three dimensional patterns, and requires no dies or tooling. In a hot air welder, the flow of hot air that floods the seam is not subject to contamination, as with the wedge welder, and there is no initial drop off of heat at the beginning of the seam. Most 10 fabricators want the speed of hot air technology, but have felt that it is difficult to obtain consistent results for many types of coated fabrics and also that it requires highly trained operators.

The typical rotary hot air welding apparatus uses hot 15 air to join together two pieces of plastic coated fabric. The welder first injects a stream of hot air from a hot air nozzle between the two pieces of coated fabric. The temperature of the hot air can be set in the range of approximately 500 to 1350 degrees F. The fabric pieces are 20 then pinched between and pulled through the apparatus by two drive wheels. The distance from the hot air nozzle and the pinch point between the two wheels is in the range of approximately .5 to .75 inch. The wheel speed determines how long the fabric is exposed to the hot air stream before 25 it passes between the wheels. With a constant air

temperature, the amount of heat energy delivered to the fabric is inversely proportional to the wheel speed; a faster speed decreases the exposure and vice versa.

Commercial hot air welders currently available on the market have a number of shortcomings. One shortcoming is the lack of accurate control of the speed of the two drive wheels. If the wheel speed varies from the required speed, then the amount of heat delivered to the seam will vary. Too much heat supplied to the weld results in burnt fabric while too little heat results in cold welds or unwelded fabric.

The problem of providing accurate wheel speed is compounded by the need to control both wheels independently.

For some fabric patterns, especially patterns with curves, one wheel may need to run slightly slower or faster than the other wheel. Commercial hot air welders typically use a single DC motor with a variable speed (voltage) amplifier. The drive energy from the motor passes through a long series of chains and pulleys to the bottom drive wheel. The drive energy to the top drive wheel first passes through a variable diameter pulley transmission that provides adjustment for the relative wheel speed and then passes through a similar set of chains and pulleys.

This arrangement is fairly inaccurate and is not easily or consistently repeatable. With any particular speed

setting, the actual wheel speed can vary with both the temperature of the amplifier and the motor windings and with the load on the motor. This is typical of a DC drive system in which there is no feedback to the motor.

5 Further, the variable diameter pulley that provides differential speed control is an inherently inaccurate mechanical device. The same differential speed setting is not repeatable between consecutive seams. In view of the inaccurate DC drive system and the variable speed
10 transmission for the drive wheels, wheel speed adjustment and calibration are constant problems. These problems are particularly evident when thinly coated fabrics are being welded and where the amount of heat energy delivered to the seam must lie within a narrow range.

15 In addition, the inaccurate control of the wheel speed results in the two edges of the fabric being joined not "in registration." In other words, at the end of the seam, one piece is shorter or longer than the other piece. Such an occurrence effects the overall quality of the product being
20 made and is especially likely to occur when two different types of fabrics, with, for example, different elastic qualities, are joined together.

Thus, there is a need for a hot air welding apparatus and welding method that provides accurate control of the
25 drive wheel speed and, consequently, accurate control of the

amount of heat applied to the seam. There is a further need for a hot air welding apparatus and method that provides a differential speed setting that is repeatable between consecutive seams and that allows the drive wheel settings 5 to be adjusted while the seam is being welded. In addition, there is a need for a hot air welding apparatus and method that joins the edges of two pieces of fabric "in registration."

Further, generally, pieces of fabric which are joined 10 for the manufacture of technical outdoor "waterproof" type clothing are stitched together to form seams. This type of seaming requires that multiple holes be punched through the fabric pieces during the sewing/threading process. Thereafter, the seam must be treated so that it is 15 waterproof. This two step process is inefficient because it requires that the stitches be inserted and that the newly made seam, and the requisite holes, be waterproofed in a second step. Further, the thread used to stitch the seam may rot or otherwise degrade over time because of, for 20 example, exposure to ultra violet light, thereby weakening the seam. In laminated fabrics, each thread hole creates an untreated exposed edge where a one fabric layer may start to separate from another layer or from the waterproofing layer. Thus, traditional threading creates hundreds of points 25 where delamination may easily occur, possibly resulting in a

poorer quality product.

Therefore, there is a need for a method of seaming garments that does not require the use of traditional stitching/sewing techniques. In particular, there is a need 5 to provide a method for seaming garments that are in the technical outdoor clothing industry, especially those with waterproof qualities, without sewing and without the need for putting needle holes in the waterproof fabric. Further, there is a need to join waterproof fabrics together in a 10 single step in order to reduce labor costs.

SUMMARY OF THE INVENTION

The present invention provides a hot air welding apparatus and related method for accurately and repeatably 15 controlling the drive wheel speed. To afford very precise control of the speed and relative rotation of the drive wheels at all times during the welding process, the present invention is provided with a computer control system and two high torque stepper motors, one for each drive wheel. The 20 computer control system allows the speed and position of the drive wheels to be regulated with a very high accuracy. Further, the computer control system allows the stepper motors to be mounted very close to the drive wheels, thereby 25 eliminating the extensive set of chains and pulleys that are inherent in the welders of the prior art and thus further

reducing the inaccuracies brought about by the stretched chains and other elements of the drive chain. The computer control system allows the drive wheel settings to be adjusted while the seam is being welded and further includes

5 an automatic ramp capability, a repeat mode, and a test strip mode. Further, the computer control system is capable of controlling the temperature and volume of air used in the welding process. The invention allows for the welding of fabrics with dissimilar thicknesses and stretch

10 characteristics.

The invention further provides a method for joining fabric pieces, and garments seamed by such methods, particularly fabric pieces for technical outdoor waterproof clothing, without the need for traditionally sewn seams.

15 Many fabrics used in outdoor technical waterproof/breathable type clothing do not bond well, either to each other or with adhesives. However, traditional sewing is undesirable because holes are put in the waterproof fabrics during sewing. In addition, threads may

20 degrade faster than the fabrics they join, weakening and reducing the life of the garment, and the perforations may weaken the fabric. Further, sewing and then sealing the threaded seams is a more expensive, labor intensive process than a one step seaming process. Material costs are also

25 reduced by the elimination of thread and, in some cases, it

also helps cut material costs by eliminating thread and possibly even seam tape if the fabrics are themselves weldable.

The main obstacles to overcome in the development of a 5 stitchless seam in a technical fabric are the properties of the fabric itself. Most technical fabrics are made of nylon, which is not weldable because it melts and shrinks too much to allow the formation of a good bond at the seam.

However, other thermal plastic materials, such as 10 polyurethane, polyvinylchloride, polypropylene and polyethylene will bond well with heat.

Further, fabric weave also affects bonding. Most technical fabrics have a tight weave to aid in water repellency. However, a tight weave prevents an adhesive 15 from permeating the fabric and forming strong bonds with the fabric fibers. Adhesive tapes may stick to nylon if the weave of the fabric is loose because the tape can encapsulate the individual fibers of the fabric, but loose weaves may be less water repellent.

20 To compound the problem further, most technical fabrics are coated or impregnated with a durable water-resistant solution (DWR). DWR's are usually silicone based. Silicone is not a thermal plastic so it will not weld and adhesives will not adhere to it well.

25 These problems can be overcome if the fabrics are

modified in one or more ways. For example, fabrics may be given thermoplastic characteristics. To accomplish this, weldable thermoplastic fibers may be included with the other threads which make up the fabric. Polyurethane threads will 5 work well due to their good welding characteristics, elasticity and abrasion resistance, but other thermoplastics will also work.

Alternatively, fabrics with thermoplastic fibers having good bonding characteristics may be seamed with thermally 10 activated adhesive tape. Though the fabric weave may be too tight for fiber encapsulation, exposed thermoplastic fibers in the fabric will still form a strong surface bond with various adhesives. The preferred seam in this situation is the butt seam. However, prayer, double butt, overlap and 15 other seams will work as well.

Further, the DWR may be formulated to have thermoplastic properties so that it is compatible with the welding process. For example, a polyurethane base may be used instead of a silicone base.

20 Further, the use of adhesive tapes and modified water-resistant solutions or modified fabrics may be combined.

Alternatively, finished products may be coated with the DWR after the seaming process.

25 Another alternative is to use a DWR with a low evaporation temperature. The welding apparatus may be

configured so that heat causes the DWR to vaporize and evacuate the bonding area the instant before the bond is formed. For example, a reflected blast of heated air that is escaping the point of the weld could accomplish this.

5 Various heat sources may be fitted to the welding apparatus, including, but not limited to a specialized hot air nozzle, steam jet or laser.

BRIEF DESCRIPTION OF THE DRAWINGS

10 Figure 1 is a perspective view of the welding apparatus of the present invention.

Figure 2 is a perspective view of the weld head cluster of the present invention.

15 Figure 3 is a perspective view of the weld head cluster in use.

Figure 4 is a side view of an alternate equivalent embodiment of the present invention.

Figure 5 is a block diagram of the computer control module of the present invention.

20 Figure 6 is a schematic showing an adhesive tape bonded to a piece of fabric.

Figure 7 is a schematic showing an apparatus for bonding adhesive tape to a piece of fabric.

25 Figure 8 is a schematic showing an apparatus for bonding a second piece of fabric to the prebonded fabric-

tape intermediate product.

Figure 9 is a schematic showing seamed fabric pieces.

Figure 10 is a schematic showing seamed fabric pieces with a cover tape added.

5 Figure 11 is a schematic showing an apparatus for bonding two pieces of fabric with an adhesive tape.

Figure 12 is a schematic showing seamed fabric pieces.

Figure 13 is a schematic showing fabric pieces seamed with adhesive tape on the inside and the outside surfaces of
10 the fabric.

Figure 14 is a schematic showing seamed fabric pieces.

Figure 15 is a schematic showing fabric pieces bonded without adhesive. Figure 16 is a schematic showing an apparatus for seaming fabric pieces that were treated
15 previously with a durable water-resistant solution.

Figure 17 is a schematic (perspective view) of an alternative embodiment apparatus.

Figure 18 is a schematic (top view) of an alternative embodiment apparatus.

20 Figure 19 is a schematic (side view) of an alternative embodiment apparatus.

DETAILED DESCRIPTION OF THE INVENTION

APPARATUS AND METHOD FOR JOINING FABRICS

The rotary hot air welding apparatus 10 of the present
5 invention is shown in figures 1-3. Referring to figure 1,
the present invention generally includes a cabinet or frame
12, a vertical post member 14, upper and lower beam members
16, 18 extending from the post member 14, and a weld head
cluster 20. The upper beam 16 is provided with a computer
10 control module 23 along its upper surface.

The cabinet 12 houses the main power supply for the
welding apparatus and the pump for the hot air assembly,
discussed below. The cabinet serves as the rigid frame or
base that supports all of the other modules of the welding
15 apparatus. It further allows the main power supply to be
protected, isolated and distributed throughout the
apparatus.

As can be seen generally in figure 1 and more
specifically in figure 2, the weld head cluster 20 includes
20 an upper wheel module 25, a lower wheel module 27 and a hot
air assembly 29. In the preferred embodiment, the upper
wheel module 25 and the hot air assembly 29 are carried by
the upper beam member 16 while the lower wheel module 27 is
carried by the lower beam member 18.

25 Each wheel module includes a drive wheel 32, 34, a

housing 36, 38 for housing the drive wheel, a stepper motor 40, 42 operatively coupled to the drive wheel, and a support member 44, 46 for supporting the module from its respective beam member.

- 5 Each stepper motor 40, 42 powers a respective drive wheel 32, 34 via an industrial timing belt and a conventional gear arrangement using, for example, simple toothed, in-line gears. Mounting the stepper motors adjacent to the drive wheels enables more accurate control of the wheel speed by
- 10 eliminating the extensive drive chain and pulley arrangements found in conventional devices.

The hot air assembly 29 of the present invention includes a nozzle 50 for directing the hot air to the seam which is operatively connected to the air pump (not shown) 15 housed in the cabinet 12. A conventional hot air assembly is utilized in the present invention. In the preferred embodiment, hot air is used as the heat source to weld the pieces of fabric together. However, the heat source can alternately take the form of a hot wedge, or a propane 20 flame.

Referring to Fig. 1, the computations necessary to control the air temperature and drive wheel speed occur within the computer control module 23. The main power is supplied from the cabinet 12, converted to the correct phase 25 and voltage, and then is supplied to the computer control

module 23.

The computer control system 23 sends accurately timed and amplified pulses to the stepper motors. Since a stepper motor rotates a specific increment of a revolution with each 5 amplified pulse, the control system allows the speed and relative rotation of the drive wheels to be regulated with a very high accuracy during the welding process. The control system, through its operator interface which includes a suitable keypad 60, switches 62, and display 64, also allows 10 the operator to more easily establish and set the exact speed and temperature parameters for the welding process. The present invention is further provided with a set of six foot pedal switches 52-56, 58 which are operatively connected to the computer control system.

15 Figure 5 illustrates a block diagram of the inputs and outputs of the computer module 23 used by the present invention. The computer module 23 includes a computer control system 75 that has as its inputs keypad 60, switches 62, and foot pedals 52-56, 58. The data from the inputs is 20 used by the computer control system 75 to control the speeds of the upper wheel module 25, the lower wheel module 27, and the hot air assembly 29 according the principles of the present invention.

25 The outputs of the computer control system 75 are connected to pulse amplifier 77, 79 that are connected the

stepper motors 40, 42, respectively, that control the speeds of drive wheels 32, 34, respectively. Each pulse amplifier 77, 79 inputs a suitable signal to the stepper motors 40, 42 to control the speeds of the drive wheels 32, 34 according 5 to the inputs from the keypad 60, switches 62 and foot pedals 52-56, 58.

The computer control system 75 is also outputted to a solid state relay 81 that controls the hot air assembly 29.

The hot air assembly 29 includes an air heater electrical 10 power supply 83, an air pump 85, an air heater 87, and air nozzle 50. The output of the computer control system 75 and the air heater electrical power supply 83 are inputted into solid state relay 81 that controls the air heater 87. The air heater 87 heats air received from the air pump 85. The 15 heated air is then output through the air nozzle 50 to heat the fabric pieces being pinched by the drive wheels 32, 34.

Figure 3 depicts the present invention in use. In operation, the hot air welding, apparatus 10 of the present invention uses hot air from the hot air assembly 29 to join 20 together two pieces of plastic coated fabric 57, 59. The welder 10 first injects a stream of hot air from the hot air nozzle 50 between the two pieces of coated fabric 57, 59. The fabric pieces 57, 59 are then pinched between and pulled 25 through the welder by the two drive wheels 32, 34, each drive wheel driven by a respective stepper motor 40, 42.

The stepper motors 40, 42 move exactly 1/400 a revolution with each amplified pulse from the computer control system.

By tracking the number of pulses sent, the control system monitors the speed and relative rotation of the drive

5 wheels. As will be discussed in detail below, the computer control system allows the operator to control the various aspects of the welding process.

An operator can use two of the foot pedals switches 52-56, 58 to give differential wheel speed commands to the 10 control system while steering the pattern pieces through the welding apparatus. Such corrective commands are useful when welding patterns having both curves and straight sections that are best welded by applying differential wheel speed control at particular places on the seam rather than 15 throughout the seam. In the preferred embodiment, the amount of the differential step is applied to one wheel only, for example, the top wheel, is approximately a 1% increase or decrease. The amount represents the incremental change to the top wheel speed that will cause a small but 20 noticeable difference or correction in the panel registration over the next several inches of seam. For example, if the top pattern piece is getting ahead of the bottom piece, the appropriate pedal press will reduce the speed of the top wheel by approximately 1% with respect to 25 the bottom wheel. The operator can give the speed

correction command by closing, a foot pedal switch while still keeping both hands on the panels as they, are fed or steered into the weld area of the apparatus. Subsequent foot pedal switch commands produce the same (additive) 5 result.

Wheel speed corrections can also be made for both drive wheels together in exact percentage steps (increase or decrease) of the current wheel speed. This feature is useful when the operator notices that either too much or too 10 little heat is being delivered to the seam while the seam is being welded. In a preferred embodiment, the amount of each step is either an approximate 5% increase or decrease. The amount represents the incremental change to the wheel speed that will result in a small but noticeable difference in 15 seam appearance. The speed correction command is given by closing a foot pedal switch, again allowing the operator to keep both hands on the pattern pieces as they are fed or steered into the weld area of the apparatus. Subsequent foot pedal switch commands produce the same (additive) 20 result.

Some closed patterned products such as tubes build up heat inside the product as a long seam is welded. This heat buildup is caused by an accumulation of hot air inside the tube. To address this problem, the control system of the 25 present invention includes a ramp function. With this ramp

function, the operator can command the control system to automatically increase the speed of both drive wheels 32, 34 by a set percentage for each repeating increment of seam, prior to performing a weld. This feature of the control 5 system allows the operator to automatically decrease the amount of heat energy delivered to the seam for those types of seams and panel geometry that tend to accumulate heat over a long seam. This will avoid excessive heat buildup in enclosed patterns with long seams and thus prevent any 10 resultant scorching or burning of the fabric. In the preferred embodiment, the speed increase is adjustable from approximately 0-5% and is imposed on the current wheel speed about every 20 inches of seam.

The computer control system is further provided with a 15 repeat mode which allows the operator to command the apparatus to repeat a set of foot pedal wheel speed corrections that were imposed on the previous seam. In the preferred embodiment, the control system automatically records, for each foot pedal correction event, the type of 20 event and the location it occurred on the seam to an accuracy of approximately 0.1 inch. By placing the control system in repeat mode before welding the next seam, the control system will automatically impose the same foot pedal corrections at the same locations. Thus, the operator can 25 concentrate on steering the panels into the welding

apparatus. The use of the repeat mode assumes that the previous series of foot pedal corrections produced the desired weld and that for the subsequent flow of the panels through the machine, the stresses on the panels, and the 5 foot pedal corrections as they were just welded are similar enough for the exact weld to be duplicated. This is the function of the repeat mode. There is a need for such a repeat function when welding panels with rotary heat sealing equipment.

10 The computer control system is also provided with a test strip mode. Prior to performing a production weld, it is necessary to find the ideal speed and temperature settings for that particular situation. The settings are sensitive to many variables including the type of fabric 15 coating, the welding pressure, the thickness of the fabric, the length of the seam, the operator's proficiency, and external factors such as the relative humidity. An operator can use the test strip mode of the present invention to weld a test strip using scrap fabric of the same type. In this 20 mode, the wheel speed is started at a higher speed than the nominal speed setting and is reduced periodically as the seam is welded. Thus, a welded test strip is produced that can be pulled apart to find where the heat energy was too low to weld and where the heat energy was so high that the 25 panels were distorted or burnt. The optimum speed would lie

about half way between those two locations on the test strip. In the preferred embodiment, there are two test strip modes, fine and coarse. For the coarse mode, the starting speed is approximately 50% faster than the nominal 5 setting and the speed decreases by approximately 5% of the nominal setting for every inch of weld. For the fine mode, the starting speed is approximately 10% faster than the nominal speed and decreases by approximately 1% for every inch of weld. The test strip mode of the present invention 10 allows the operator to find the ideal weld speed and thereby assure the highest quality of weld for that set of conditions.

Hot air welders of the prior art deliver a constant temperature air flow to the fabric seam being welded. The 15 speed of the fabric flowing through the machine is controlled to limit the exposure of the fabric to the air stream and thereby maintain an adequate welding process. This constant speed, constant temperature arrangement requires that a complete seam must be welded at the same 20 nominal speed. Thus, if the pattern includes a curved portion and a straight portion, the presence of the curved portion would require that the entire seam be welded at a slower speed. Understandably, this has limited production. The control system of the present invention, however, 25 enables the temperature of the air stream to be changed

during welding. The control system can then adjust the wheel speed to keep the welding process at an ideal speed/temperature combination, regardless of the temperature the air stream produces. With this feature, the hot air 5 welder of the present invention can operate much more like a sewing machine in that the operator has some ability to speed up for the long straight sections and to slow down to accommodate any curves in the pattern.

Of course, the present invention is not limited to the 10 embodiment shown in figure 1. An alternate equivalent embodiment of the apparatus shown in figure 4 includes an extension 118 between the beam 116 and the post member 114. The height of the post 114 has also been increased in order 15 to provide additional support to the beam 116 and the extension 118. The remaining structure of the rotary hot air welding apparatus 110 shown in figure 4 generally corresponds to the structure shown in figure 1 and also generally includes a cabinet or frame 112, a weld head cluster 120, a computer control module 123, and foot pedals 20 152-156, 158. These alternate arrangements allow a wider variety of finished products to be made.

Since the welding apparatus of the present invention is easier to use than welding apparatus of the past, this reduces the stress on the operator by reducing the number of 25 variables that the operator must monitor while welding a

seam. Operators, in turn, produce higher quality seams with lower waste from process errors. The present invention also enables fabrics having a very thin coating to be welded successfully. In the past, these fabrics have been 5 difficult or impossible to weld.

STITCHLESS SEAMING

Fabrics used for technical outdoor clothing may be comprised of one or more layers of material. For example, 10 two or three layer fabrics formed of an outer nylon shell, a breathable membrane and, for three layer fabrics, an inner scrim, are common. Single layer fabrics, of nylon, for example, are also common.

The type of fabrics used in the preferred embodiments 15 are waterproof and breathable tri-laminate fabrics from companies such as Gore and Associates (Newark, Delaware), Burlington Klopman Fabrics (Greensboro, North Carolina), and Torray Industries, Inc. (Tokyo, Japan). These fabrics have a relatively loose weave which aids the bonding process.

20 However, a variety of synthetic and natural fabrics may be joined according to the method of the invention.

The adhesive tapes used in the preferred embodiments are of various types and are chosen based on the application. For example, monolithic tapes are a single 25 layer of heat activated adhesive, usually with a removable

paper backing. Dual sided tapes have a high temperature melt layer and a low temperature melt layer which acts as the adhesive. Some tapes have a scrim or a breathable membrane as a backing for the adhesive.

5 The equipment used in the preferred embodiments is a Seamtek International SMARTSEAL (TM) ROTARY HOT AIR WELDER, Model SP. The welder was configured as a taping machine according to the parameters detailed in the preferred embodiments. Some of the tape/fabric combinations required 10 the upper wheel of the SMARTSEAL (TM) welder to run at a slightly different speed than the lower wheel to remove wrinkles or other distortions. As detailed above, this feature is incorporated into the welding apparatus.

15 Prayer Seam

In this embodiment a monolithic heat activated seam tape was used to bond pieces of the garment pattern with heat. Using a SMARTSEAL (TM) welder to apply heat and pressure, the tape was bonded to the first piece of fabric.

20 Referring to Fig. 6, a first piece of two or three layer fabric 202 is shown with a piece of heat activated adhesive tape 206 attached to the edge 208 of the fabric outer surface 210. Fig. 7 shows how the attachment of the tape was accomplished with the weld wheels 212, 214 positioned to 25 press the fabric 202 and the tape 206 together after heat is

applied by the hot air nozzle 216.

Fig. 8 shows the arrangement used to adhere the second piece of fabric 204 to the tape 206 which is already bonded to the first piece of fabric 202. This is accomplished by 5 running both pieces of fabric through the welder 218 so that the heat activated adhesive is reactivated and bonded to the second piece of fabric 204. The result of the second welding operation is shown in Fig. 9.

To increase the strength and waterproof qualities of 10 the seam a second piece of tape, or cover tape 220 was applied to the inside surface 222 of the fabric over the prayer seam 224. This tape also makes the prayer seam 224 lay down flat for the comfort of the individual wearing the garment. The cover tape 220 may be a seam tape that is 15 currently used in the industry to seal stitched seams, and may have a backing similar to the inside surface material of the fabric to which it is being bonded.

Though the seam shown in Fig. 10 appears to be bulky, it is less than 1/8" thick from the inside of the fabric to 20 the outside of the fabric.

Machine parameters

Temperature: 900 °F

Speed: 60 IPM (inch per minute)

25 Airflow: 100 scfh (standard cubic feet per hour) (air

flow must be set low so the adhesive is not blown away when it becomes liquid)

Weld Pressure: 40 psi (pounds per square inch)

Wheel Type: Silicone 1" wide top and bottom

5 Wheel differential: +2% (depending upon fabric and tapes used)

Nozzle type: SMARTSEAL (TM) Adjustable Taping Nozzle, set to 7/8".

Seam Width: 7/8"

10 Clamp Pressure: 15 psi

Butt seam

Another type of seam that can be used to join fabric pieces for technical outdoor garments is the butt seam. In 15 this process, as shown in Fig. 11, the two pieces of fabric 202, 204 are put through the welder 218 simultaneously with the heat activated seam tape 206. In this embodiment, the tape has a nylon fabric backing that matches the outer nylon shell of the fabric pieces being used. Fig. 12 shows the 20 finished butt seam 226, created when the fabric pieces 202, 204 are brought together and the tape 206 is bonded to both pieces simultaneously.

Machine Parameters

25 Temperature: 900 °F

Speed: 80 IPM

Airflow: 250 scfh

Weld pressure: 60 psi

Wheel type: silicone 1" wide top and bottom

5 Nozzle type: SMARTSEAL (TM) Adjustable Taping Nozzle, set to 7/8".

Seam Width: 7/8"

Clamp Pressure: 15 psi

10 **Double Tape Butt Seam**

The Double Tape Butt Seam is similar to the Butt seam.

The difference, as shown in Fig. 13, is that in the Double Tape Butt Seam 228 a second piece of tape 207 is added to the inside of the fabric pieces in a second bonding

15 operation. The second tape 207 is also a heat activated seam sealing tape and may be chosen so that it matches the material of the inside surface of the fabric pieces and may be a tape that is commonly used to seal stitched seams. For example, if the inside of the fabric is a tricot scrim then 20 the tape 207 could have a backing that is made of the same tricot material so that the final product has a better finished appearance. The second tape increases seam strength and water resistance.

Machine Parameters

Temperature: 900 F

Speed: 80 IPM

Airflow: 250 scfh

5 Weld pressure: 60 psi

Wheel type: silicone 1" wide top / Steel 1" wide bottom

Wheel differential: +1 or 2% (depending upon fabric and
tapes used)

Nozzle type: SMARTSEAL (TM) Adjustable Taping Nozzle, set
10 to 7/8".

Seam Width: 7/8"

Clamp Pressure: 15 psi

Overlap Seam

15 The Overlap Seam is similar to the prayer seam. In
this embodiment one piece of fabric had a monolithic heat
activated adhesive tape applied to it, as in the prayer
seam. Then both fabric pieces were put through the welder
again to reactivate the tape so that it bonded to the second
20 piece of fabric. The resulting structure is shown in Fig.

14. The difference between the prayer seam and the overlap
seam is that in the prayer seam the tape adheres to the
outside of both fabrics (See Fig. 9), where in the overlap
seam the tape adheres to the outside of one fabric and the
25 inside of the other fabric. One problem that may arise with

the overlap seam is that the edge 209 of the second (outer) fabric 204 is left exposed. However, the edges 208, 209 of the fabric pieces are generally sealed closed during the bonding operation by the heat and pressure applied to the 5 fabric. Further, any excess material, such as frayed edges, will generally be removed by the bonding operation.

Optionally, the outer fabric edge 209 may be folded into the weld so that tape bonds to the turned in edge of the outer fabric

10

Machine Parameters

Temperature: 900 F

Speed: 80 IPM

Airflow: 250 scfh

15 Weld pressure: 60 psi

Wheel type: silicone 1" wide top and bottom

Nozzle type: SMARTSEAL (TM) Adjustable Taping Nozzle, set to 7/8".

Seam Width: 7/8"

20 Clamp Pressure: 15 psi

Prayer Seam Without Adhesive

Fig. 15 shows a Prayer Seam 234 which bonds the fabric pieces without the need for sewing or an adhesive. The 25 fabric pieces are run through the SMARTSEAL (TM) welder and

thermoplastic fibers incorporated into the fabric pieces will melt and bond to one another to form a seam. Bonding takes place at point 236.

In this embodiment an appropriate fabric will be
5 comprised of at least some bondable thermoplastic fibers. The exact amount of thermoplastic fibers used in the fabric can be adjusted so that the final product has strong bonds and appropriate water resistant characteristics.

10 **Method for Seaming DWR Treated Fabrics**

Fig. 16 shows a method for bonding pieces of fabric without stitching even after the fabric has been treated with a DWR solution which has poor bonding characteristics.

As the pieces of fabric 202, 204 approach the weld wheels
15 212, 214 they are exposed to a heat source 238, such as a hot air nozzle, steam jet or laser which vaporizes and evacuates the DWR on the fabric while partially melting the thermoplastic fibers in the fabric. The DWR solution evaporates at about point 242. The fabric is then
20 compressed between the weld wheels 212, 214. Thermal bonding occurs at point 240. Various types of seams may be formed in this manner.

Discussion of Machine Settings

25 **Air temperature:** is dependent on adhesive melt point and the

speed at which the fabric travels through the machine.

Airflow changes also affect the amount of heat delivered to the tape/fabric.

5 Speed: was 60-80 inches per minute in the preferred embodiments. Faster speeds are possible for production.

The maximum speed is dependent upon the adhesive melt points, temperature of the air and the rate of airflow.

10 Airflow: must be controlled to prevent cold spots on the tape, to prevent the adhesive from being blown away by the force of the heated air and to prevent burning of the tape.

Generally, the highest possible airflow is used. In the preferred embodiments an airflow of approximately 100-200

15 scfh was used due to the low speeds employed. Higher airflow rates may be necessary at higher production speeds.

Both airflow volume and pressure can be controlled. In the preferred embodiments, when the airflow rate was below 200 scfh the power limiting in temperature controller was be set

20 to 80%.

The temperature controller unit has a functional setting that allows the operator to control both the dwell (length of time), frequency and intensity of the pulse energy that it sends to the heating element. Airflow and

25 temperature may be controlled with standard devices known in

the industry or may be controlled by the computer control module of the present invention. Thus, for example, a setting of 80% means that the heating element will receive pulses from the controller at a 20% lower power differential 5 than a setting of 100% (baseline). The controller can be set higher or lower than the baseline of 100%.

Weld Pressure: was set at 40-60 psi. This adjustment is affected by the thickness of the adhesive on the tape. The 10 higher the pressure the further the adhesive spreads out. To meet appearance requirements the adhesive must stay within the confines of the backing material for tapes that remain exposed. During the time that the welding or taping operation is not in progress, the pressure exerted by the 15 wheels on the material may be reduced so that it is merely sufficient to hold the fabric in place. This is generally referred to as the clamp pressure.

Wheel type: Selection of an appropriate wheel type is 20 important. Wheel width must match or be wider than tapes to ensure uniform pressure of the entire surface of the tape. Silicone wheels were used in all of the preferred embodiments to help prevent adhesives from sticking to wheels and to conform to seam profiles. A steel wheel may 25 be used on the lower wheel module to help drive the molten

adhesive deep into the scrim of three layer fabrics.

Wheel Differential: is often critical to the formation of a good seam. To remove wrinkles or adjust for situations

- 5 where a tape stretches more or less than a piece of fabric, or where two pieces of fabric have dissimilar thicknesses and/or stretch characteristics, the upper wheel must run at a slightly different speed than the lower wheel. For example, when a stretch fabric is used with a non-stretch
- 10 tape one wheel may need to run at a different speed than the other wheel in order to prevent bunching of the tape or fabric. Similar registration problems may be encountered even in fabrics that generally are considered to be non-stretch fabrics if pattern pieces are joined where one piece
- 15 is cut along the bias and another was cut across the bias because the fabric pieces will still, to some degree, stretch differently.

Nozzle Type: The SMARTSEAL (TM) welder is provided with both

- 20 taping nozzles and welding nozzles for various applications.

Seam Width: may vary between about 1/4" - 2" depending on the application.

Other Alternative Embodiments

By making use of adhesive tapes, fabrics containing at least some bondable fibers, bondable DWR coatings and loosely woven fabrics, either individually or in various 5 combinations, such as, for example, adhesive tapes combined with fabrics containing bondable fibers, various technical garments can be seamed without the need for traditionally sewn seams.

10 Extruded Materials Welded to Films

Further, the methods and apparatuses of the invention may be applicable to the joining of extruded thermoplastic materials to films, such as in swimming pool liners, abrasion strips on inflatable boats, window shades and many 15 other applications. The extruded materials and films may be made of numerous thermoplastics including, but not limited to, polyurethane, polyvinylchloride, polyethylene and polypropylene. Since the extruded materials and films are not necessarily made of the same materials and, even if they 20 are made of the same materials, generally, will have different dimensions, thicknesses and elasticity's, the apparatus of the invention will insure that the different materials are joined, usually by welding, at smooth seams.

Helium Envelopes

The invention apparatus may be modified in order to accommodate the joining of materials to create pouches or gores for applications as diverse as helium balloons, blimps 5 or zeppelins.

One preferred embodiment of the invention suitable for such an application is shown in Figs. 17, 18 and 19. Two pieces of fabric are passed through the welding/taping apparatus of the invention. This embodiment comprises edge 10 sensor wheels 244, 246, 244a, 246a which can be used to track preplaced registration marks on the fabric pieces 248, 250 or the actual edges 252, 254 of the fabric pieces. The sensor wheels assist with the movement and precise alignment of the fabric in either the forward/back or side-to-side 15 directions.

The fabric pieces then continue to pinch rollers 256, 258, 256a, 258a which precisely control forward/back movement and hold the fabric pieces to help facilitate welding or taping. In Figs. 17, 18 and 19 pinch rollers 20 256, 258 control a first fabric piece 248 and pinch rollers 256a, 258a control a second fabric piece 250. As the fabric pieces continue they pass between rollers 260, 262 which apply structural tape 264, after heating by a heating element (not shown) at point 266, to the bottom of the 25 fabric pieces to form a butt seam. The fabric pieces then

continue further down the line to rollers 268, 270 which apply a finishing tape 272, after the tape is heated by a heating element (not shown) at point 274, to the side of the butt seam opposite the structural tape, thereby forming a 5 double tape butt seam.

In this embodiment, each sensor wheel 244, 246, 244a, 246a may be controlled by one motor (not shown) and moved by its axis (see Fig. 18) so that the fabric movement can be controlled in four directions. Alternatively, sensor wheels 10 are available in the marketplace that have, on their perimeter, smaller wheels whose rotational axis is perpendicular to that of the sensor wheels. This design will be controlled by two motors per sensor wheel and will also allow for movement in four directions. Each pinch 15 roller may also be independently controlled by one motor.

Allowing each wheel and roller to be controlled independently allows fabric pieces to be neatly joined even if they are different lengths because the computer control module can automatically adjust for length variations 20 between the two fabric pieces as the welding/taping proceeds. The result is that two pieces of fabric can be neatly joined even if one piece is significantly longer than the other because the computer control module will adjust for the length differences more or less equally across the 25 entire length of the seam. For example, an asymmetrical gore

can be formed by neatly seaming a 623 foot length of fabric to a 685 foot length of fabric without any bunching. This task would be practically impossible by hand.

As detailed above, data concerning the movements of all 5 wheels/rollers can be stored by the computer control module so that similar welding/taping operations are easily repeated.

Enhanced Memory and Programmability

10 In addition, the welding/taping apparatus used to seam the fabrics may be further equipped with a programmable memory which retains settings data when a product is produced so that the data can be retrieved and used when an identical product is produced. This feature would allow an 15 operator to do a single programming run and then repeatedly retrieve the data when identical products are being produced. Variable stored in a programmable memory could include: machine configuration, fabric vendor, product ID, lot number, material color, coating weight, coating type, 20 coating method, scrim material, scrim weave weight, scrim weave ounces (i.e. denier), temperature, upper wheel speed, lower wheel speed, air volume, nozzle size, nozzle type, nozzle position, heater power setting, weld pressure, weld type, wheel sizes for upper and lower wheel modules, wheel 25 types for upper and lower wheel modules, whether or not a

ramp was used and, if used, the percentage of change. Other variables may also be recorded by the programmable memory.

It should be understood that various changes and
5 modifications to the preferred embodiments described herein
will be apparent to those skilled in the art. For example,
the use of stepper motors to achieve the high accuracy and
repeatability of the system could alternately be achieved by
using a traditional DC servomotor system with an encoder
10 feedback to the computer control system. Such changes and
modifications can be made without departing from the spirit
and scope of the instant invention and without diminishing
its attendant advantages. It is therefore intended that
such changes and modifications be covered by the appended
15 claims.

What is claimed is:

1. A method for joining a first and a second piece of fabric for use in technical clothing, comprising:
 - 5 (a) heating a thermally activated adhesive tape,
 - (b) applying pressure to the tape and said first piece of fabric so that they bond,
 - (c) reheating the thermally activated adhesive tape, and
- 10 (d) applying pressure to said first piece of fabric, the tape, and said second piece of fabric so that the tape bonds to said second piece of fabric and a seam is formed.
2. The method of claim 1, wherein said bonding creates a prayer seam.
- 15 3. The method of claim 2, wherein a cover tape is bonded to the prayer seam.
- 20 4. The method of claim 1, wherein said bonding creates an overlap seam.
- 25 5. The method of claim 1, wherein said pieces of fabric are subsequently treated with a durable water-resistant solution.

6. A method for joining a first and a second piece of fabric for use in outdoor clothing, comprising:

- (a) heating a thermally activated adhesive tape,
- 5 (b) applying pressure to the tape and said first and second pieces of fabric so that the tape bonds to both pieces of fabric and a seam is formed.

7. The method of claim 6, wherein the bonding creates
10 a butt seam.

8. The method of claim 7, wherein a second tape is bonded to the seam to create a double tape butt seam.

15 9. The method of claim 6, wherein said pieces of fabric are subsequently treated with a durable water-resistant solution.

10. A method for joining a first piece and a second
20 piece of fabric for use in technical clothing, comprising:

- (a) heating said first and second pieces of fabric,
- (b) applying pressure to said first and second pieces of fabric so that they bond to form a seam.

25 11. The method of claim 10, wherein said fabric pieces

are comprised of at least some heat-bondable thermoplastic fibers.

12. The method of claim 10, wherein said fabric pieces
5 are coated, before joining, with a durable water-resistant solution, said solution having heat-bondable characteristics.

13. The method of claim 10, wherein said bonding
10 creates a prayer seam.

14. A method for joining a first piece and a second piece of fabric for use in outdoor clothing, wherein said fabric pieces have been treated previously with a durable
15 water-resistant solution that does not have good heat-bonding characteristics, comprising:

(a) heating a thermally activated adhesive tape and said first piece of fabric until the solution vaporizes from said first piece of fabric,
20 (b) applying pressure to said first piece of fabric and the adhesive tape until they bond,
(c) heating the thermally activated adhesive tape and said second piece of fabric until the solution vaporizes from said second piece of fabric,
25 (d) applying pressure to said first piece of fabric,

the adhesive tape and said second piece of fabric until they bond to form a seam.

15. A method for joining a first piece and a second
5 piece of fabric for use in outdoor clothing, wherein said fabric pieces have been treated previously with a durable water-resistant solution that does not have good heat-bonding characteristics, comprising:

(a) heating a thermally activated adhesive tape and
10 said first and second pieces of fabric until the solution vaporizes from said pieces of fabric,

(b) applying pressure to the first and second pieces of fabric and the adhesive tape until they bond to form a seam.

15 16. The method of claim 14, wherein the heating step is accomplished by use of a heating device selected from the group consisting of a hot air nozzle, a steam jet and a laser.

20 17. The method of claim 15, wherein the heating step is accomplished by use of a heating device selected from the group consisting of a hot air nozzle, a steam jet and a laser.

25 18. The method of claim 1, wherein said pieces of

fabric have dissimilar stretching characteristics.

19. The method of claim 6, wherein said pieces of
fabric have dissimilar stretching characteristics.

5

20. The method of claim 10, wherein said pieces of
fabric have dissimilar stretching characteristics.

10 21. The method of claim 14, wherein said pieces of
fabric have dissimilar stretching characteristics.

22. The method of claim 15, wherein said pieces of
fabric have dissimilar stretching characteristics.

15 23. The method of claim 1, wherein the tape and at
least one piece of fabric have dissimilar stretching
characteristics.

24. The method of claim 6, wherein the tape and at
20 least one piece of fabric have dissimilar stretching
characteristics.

25 25. The method of claim 10, wherein the tape and at
least one piece of fabric have dissimilar stretching
characteristics.

26. The method of claim 14, wherein the tape and at least one piece of fabric have dissimilar stretching characteristics.

5

27. The method of claim 15, wherein the tape and at least one piece of fabric have dissimilar stretching characteristics.

10 28. A garment comprising at least a first and a second piece of fabric, wherein at least said first piece of fabric and said second piece of fabric are joined at a seam created by the method of claim 1.

15 29. A garment comprising at least a first and a second piece of fabric, wherein at least said first piece of fabric and said second piece of fabric are joined at a seam created by the method of claim 6.

20 30. A garment comprising at least a first and a second piece of fabric, wherein at least said first piece of fabric and said second piece of fabric are joined at a seam created by the method of claim 10.

25 31. A garment comprising at least a first and a second

piece of fabric, wherein at least said first piece of fabric and said second piece of fabric are joined at a seam created by the method of claim 14.

5 32. A garment comprising at least a first and a second piece of fabric, wherein at least said first piece of fabric and said second piece of fabric are joined at a seam created by the method of claim 15.

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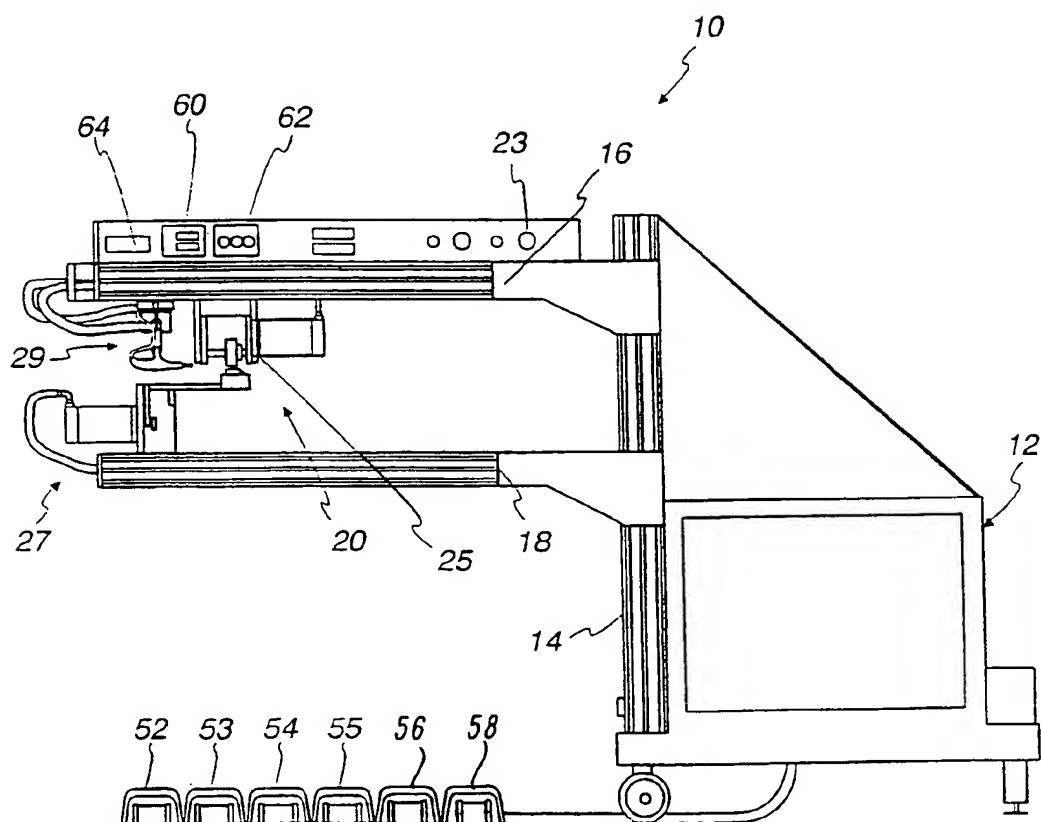
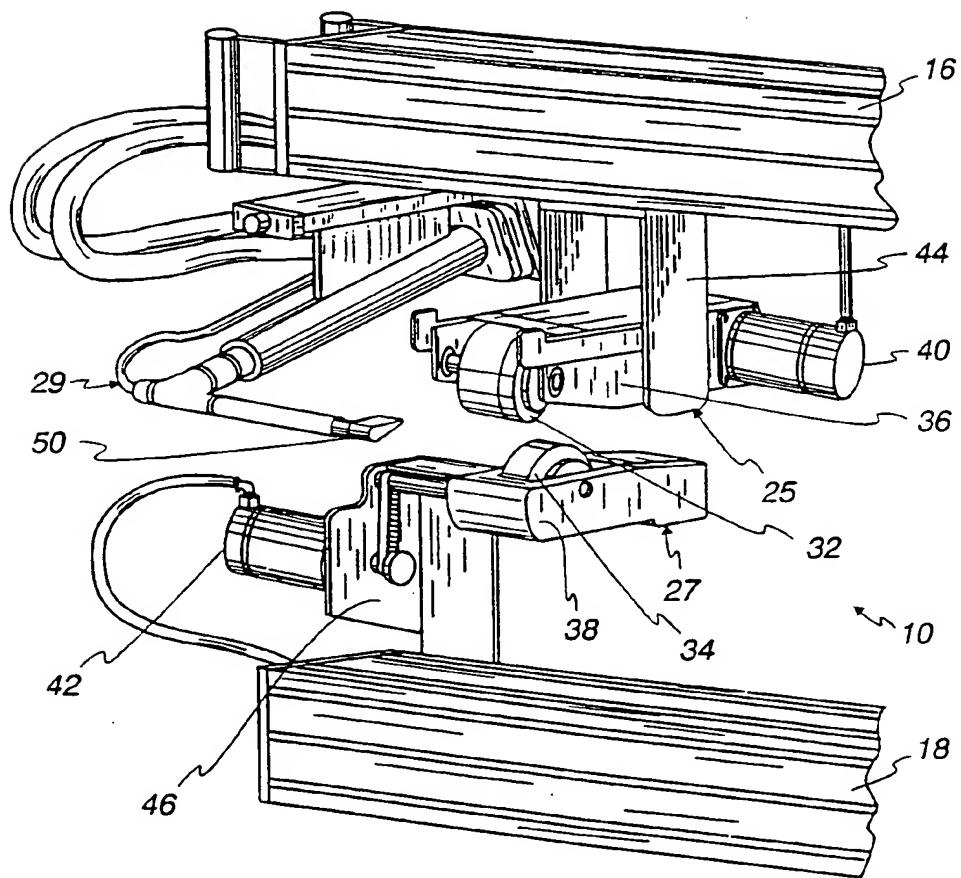


FIG. 1

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FIG.2



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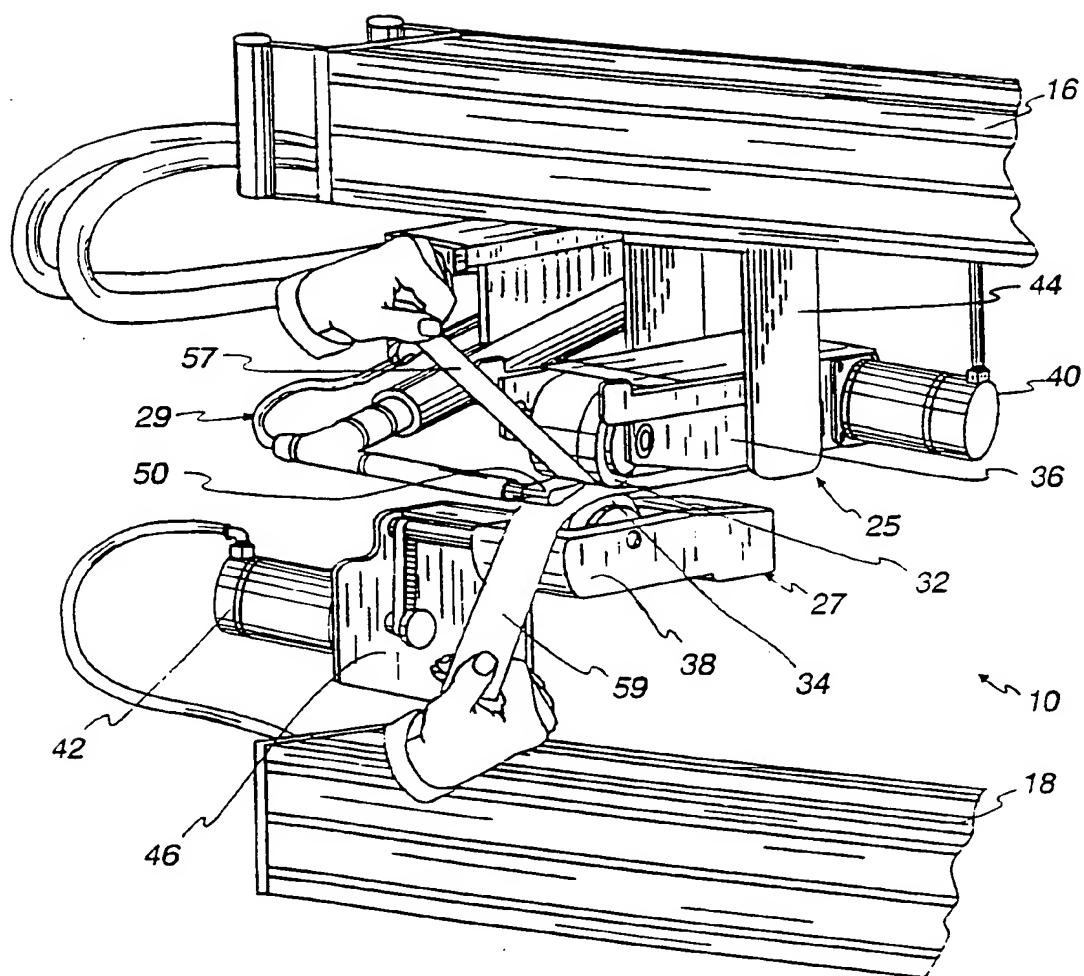
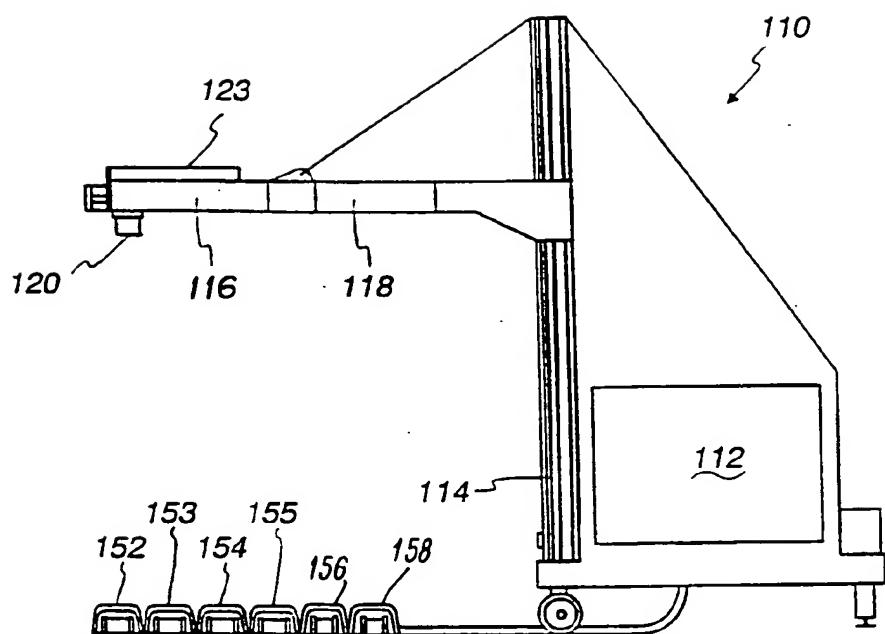
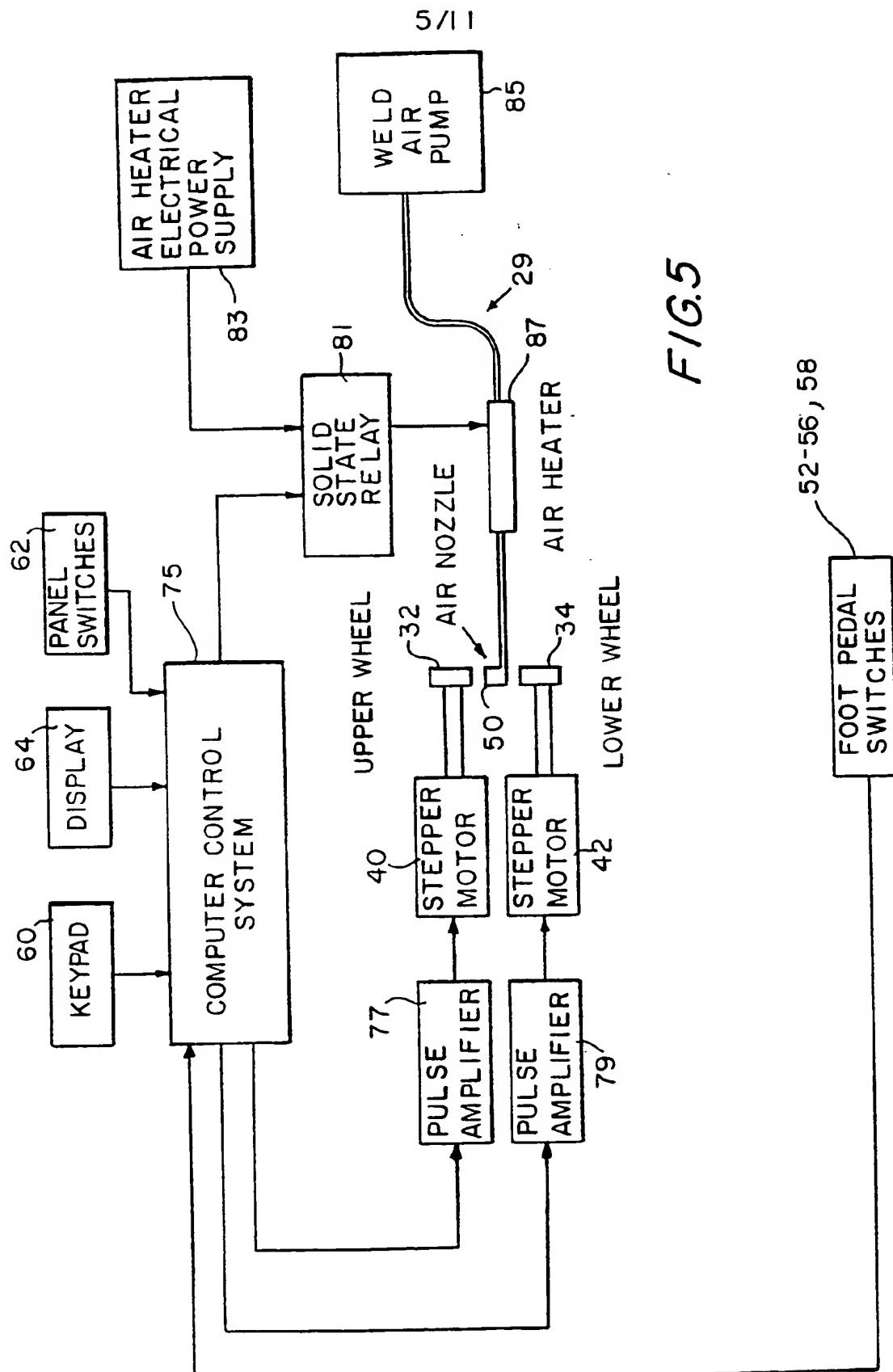


FIG.3

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FIG.4





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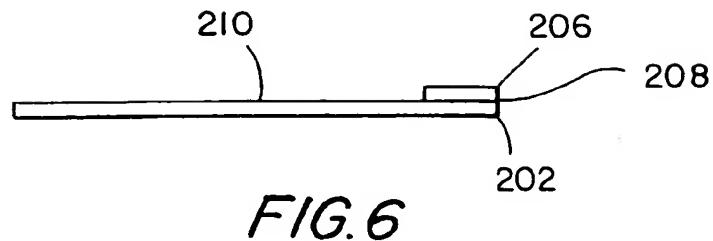


FIG. 6

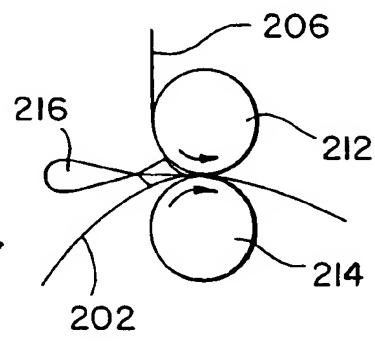


FIG. 7

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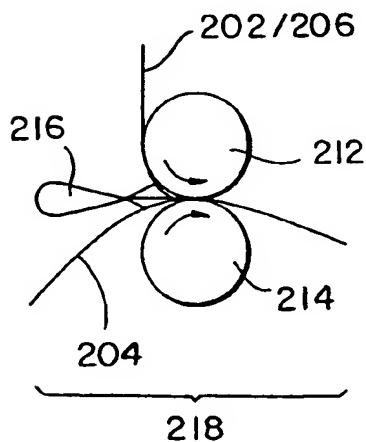


FIG. 8

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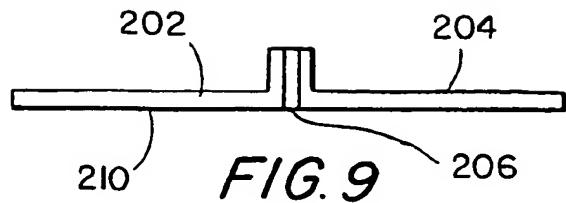


FIG. 9

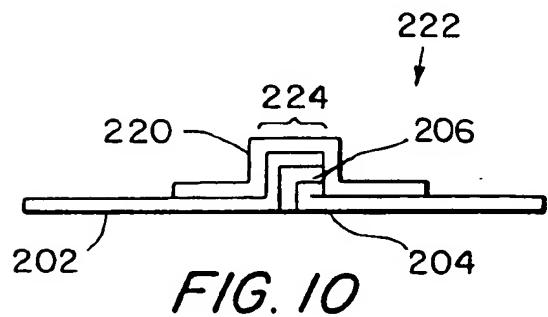


FIG. 10

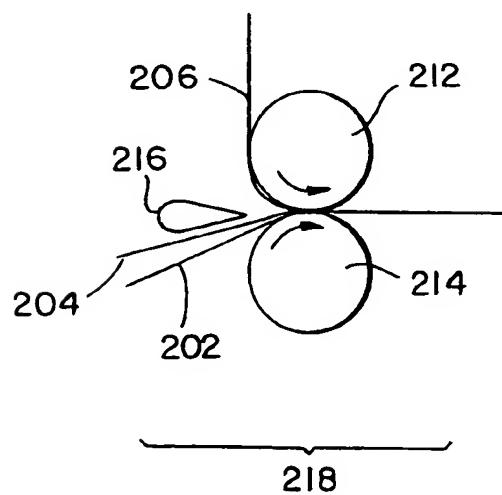
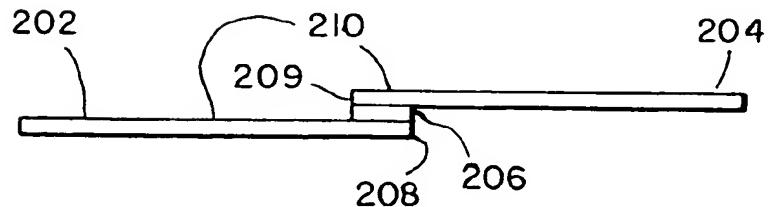
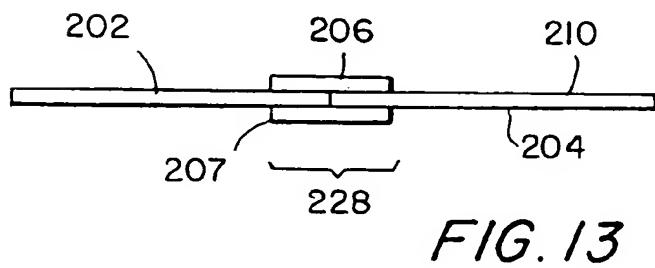
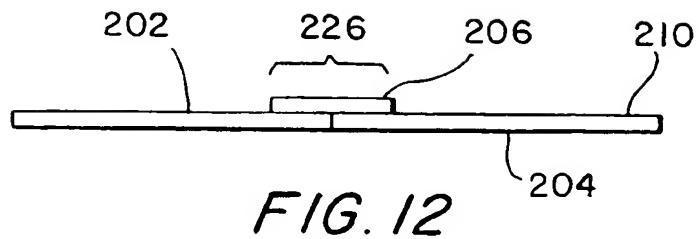


FIG. 11

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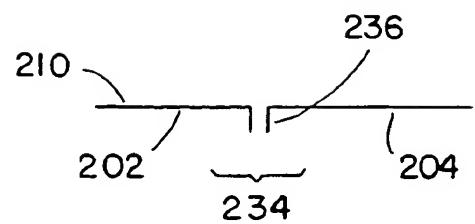


FIG. 15

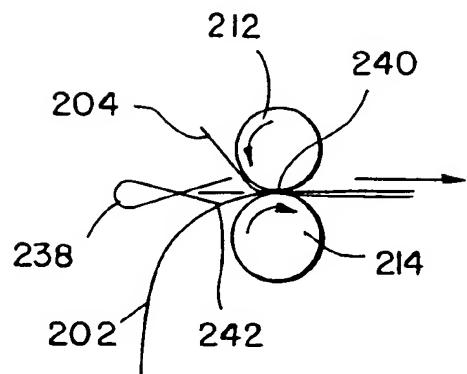
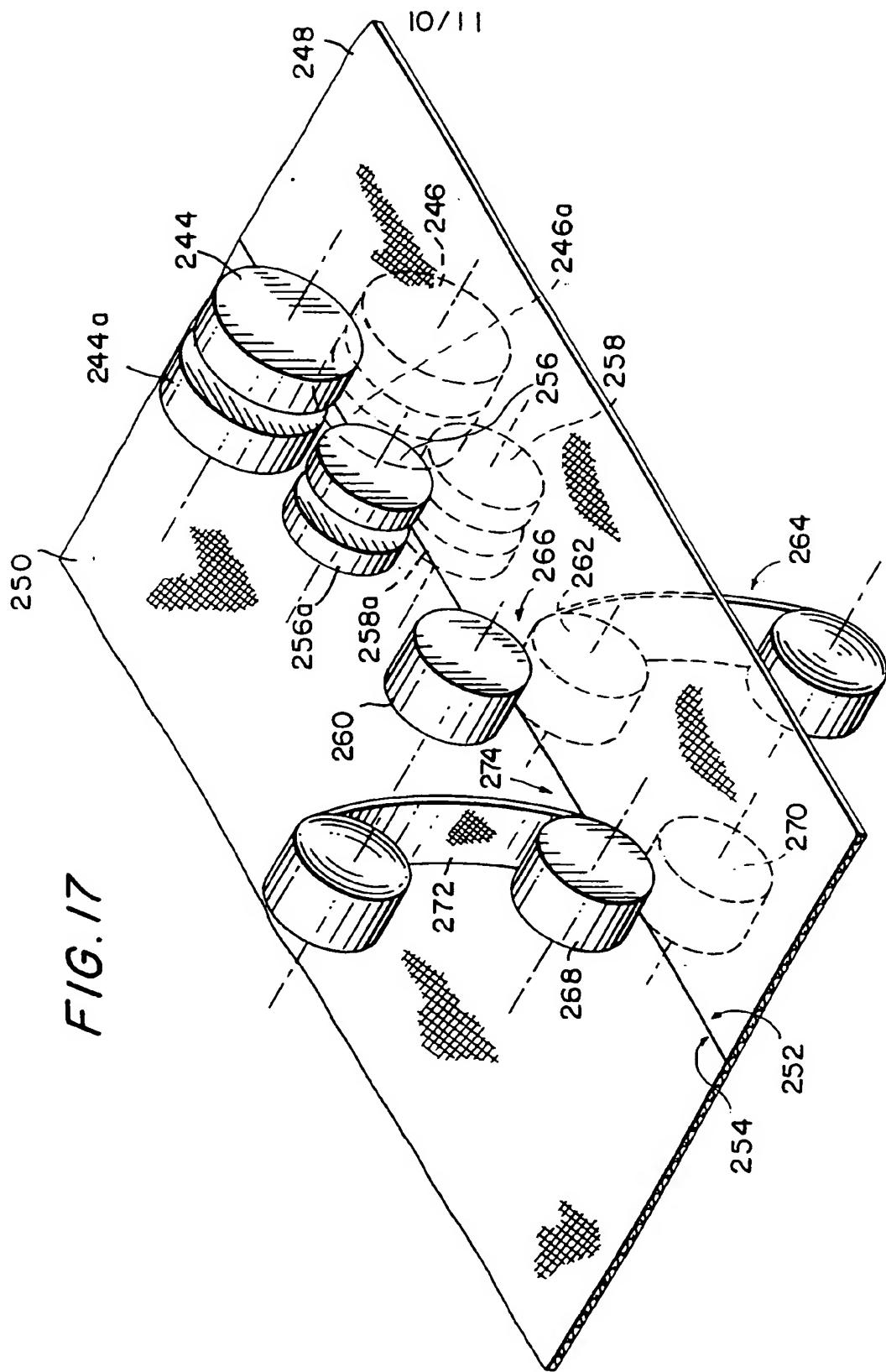


FIG. 16



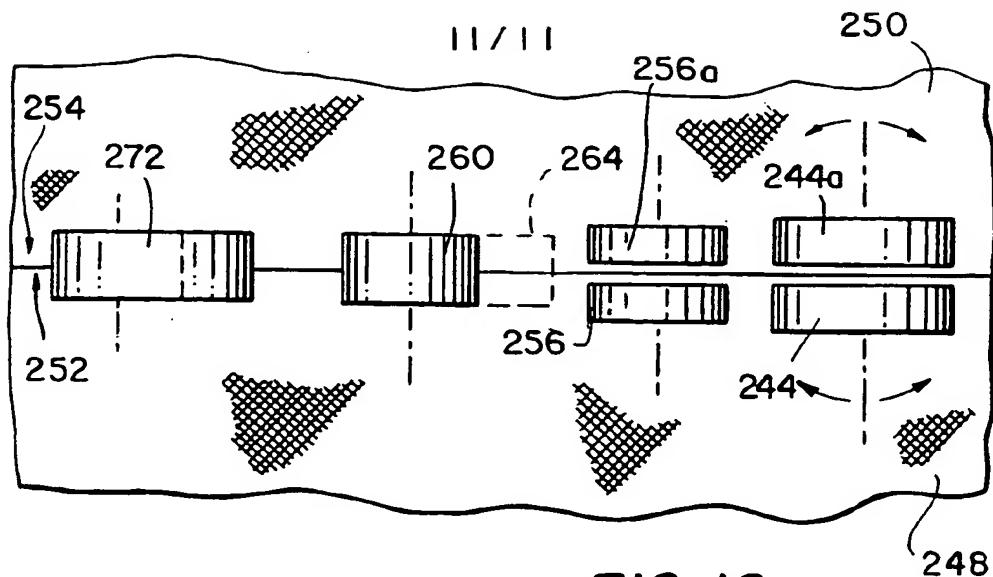


FIG. 18

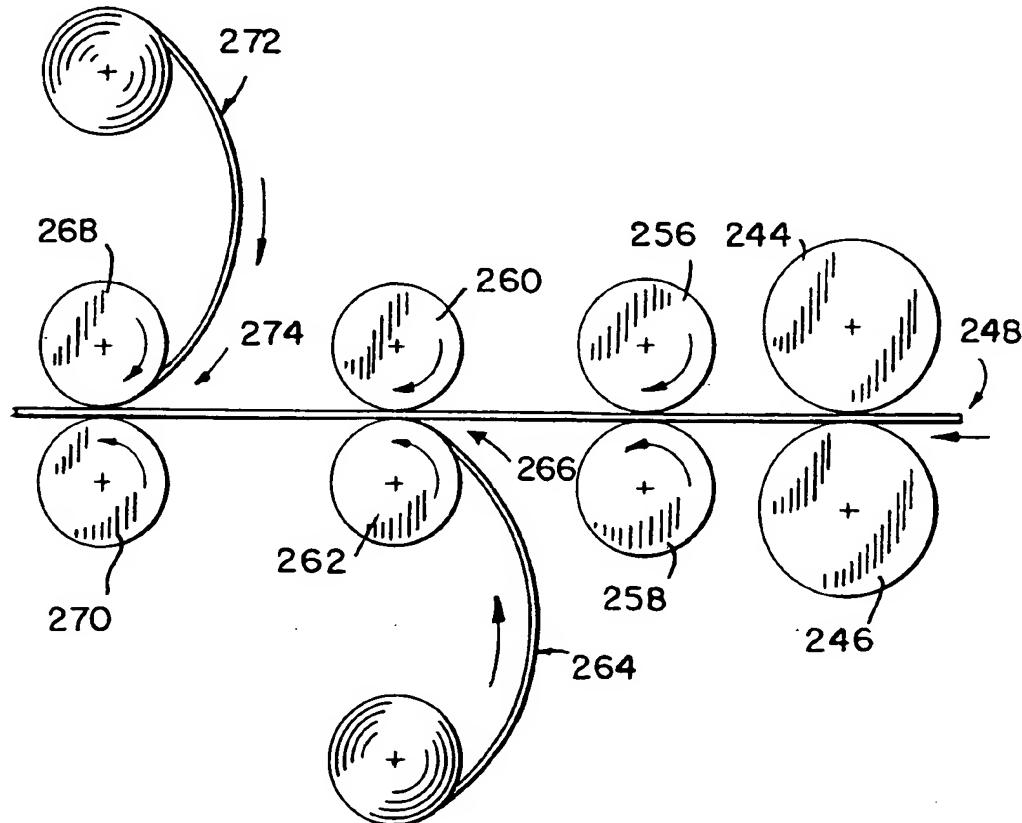


FIG. 19

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US01/12960

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) :B32B 35/00

US CL :Please See Extra Sheet.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 156/64. 82, 157, 272.2, 272.8, 304.3, 304.6, 359, 361, 367, 378, 497, 499, 555; 428/58

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,435,457 A (SERVO et al) 06 March 1984, col. 3, lines 31-58.	6-13, 19, 20, 24, 25, 29, 30
Y	US 3,804,697 A (JACOBI) 16 April 1974, col. 2, lines 22-47.	6-13, 19, 20, 24, 25, 29, 30

Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:	"T"	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	"X"	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
E earlier document published on or after the international filing date	"Y"	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&"	document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means		
P document published prior to the international filing date but later than the priority date claimed		

Date of the actual completion of the international search

27 JUNE 2001

Date of mailing of the international search report

01 AUG 2001

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INTERNATIONAL SEARCH REPORT

International application No.
PCT/US01/12960

A. CLASSIFICATION OF SUBJECT MATTER:
US CL :

156/64, 82, 272.8, 304.3, 304.6, 359, 361, 367, 378, 497, 499, 555; 428/58